Work Order January-23-13 9				Page 1							
Revision ID:	D2235-1 Basket Rib	A	ccept	*N900	040	100	)*	Setup	Start Stop	*N:	S1*
	2/04/13 <b>Start Qty:</b> 2.00	*3.13	X	Cust Item ! Customer:	ID:					IV.	
Approvals:	Process Plan: MC5	Date: /3-0/-ZY	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:	,	<b>SPC (Y/N):</b>	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description	**************************************	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep: Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				-						THE EMPLOYMENT OF THE STATE OF
D2235	Rev B1										
*100*	Large Fab		0.00				(ISX)	)	1	13-0	1-4
Large Fab Large Fab		3166-1 and cut as per dwg D22 tion markings on tube 3- deburn		nove				<del></del>			
110 <b>*4.4.0*</b>	QC6- Inspect dimension	ons to drawing	0.00								OA C
*110* QC Quality Control	Memo		0.00				US	ר ג	2-Q	1-04	<b>09</b> -
120	Identify as per dwg &	Stock Location:	0.00						Κ.,		A 4
*120* Packaging	Memo		0.00				15×	<u> </u>	3-4-	4 (	
Packaging							1				

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE

OA Closed: Date:

												QA Closea.					
Work Orde	ar.					DISPOSITION				AGAINST	AINST DEPARTMENT/PROCESS						
i	Part No.					Rework Scrap		Skid-tube Crosstube  Machining Small Fal			-	<b>⊣</b>			Engineering Quality		
	•		-			Use-as-is	1   7	Therm	noforming	ning Finishing Rec/Store/Packaging				Other			
NCR I	No.				<del> </del>	Work Order Update	]		Large Fab	Composite		·	Supplier				
Root					Descri	ption of work order update	Init	tial	Ac	tion		Sign &					
Cause		Date	Step	Qty	,	or Non-conformance	Chie	f Eng	Desc	ription		Date	Verification	<u> </u>	QC Inspector		
Doc/Data																	
Equip/Tooling													- ,				
Operator																	
Material													i				
Setup															-		
Other															*		
Process																	
Supplier														ľ			
Training			 							1				ι			
Unapproved							<u> </u>						<u></u>				
						F.	AULT	CATE	GORY								
Landi	ng G	ear				General					_	•			1		
		Bending			L	Bend	G	rain				Ovalized	:		Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route	Шн.	ardwa	re		L	Over/Under	tolerance	<u> </u>	Temperature/Cure		
50		Cracks				Broken/Damaged	In	specti	on Incomplete			Part Incorre	ct		Weld		
		Crushed/	Crimped.			Burrs	In	struct	ions Incomplete/	Unclear		Part Lost/Mi	issing	Ĺ_	Wrong Stock Pulled		
		Cuffs				Contamination	$\square$	1ainte	nance			Part Moved					
		Heat Trea	t			Countersink	$\square$ V	lislabe	led			Positioned V	Vrong		•		
		Inspection	n Strip in	Tube		Cut Too Short	$\square$	lisreac	i			Power Loss/	'Surge		Other		
		Ripples in	Bend			Drill Holes		ffset									
		Torque W	aves in E	xtrusio	n 🗆	Drawing	o	ut of (	Calibration								
		Turning S	equence			Finish	□ o	ut of S	Sequence								
		Wave/Tw	ist in Tub	oe .		Folio	По	utside	Dimensions								

Work Ord January-23-13		5126		*961				Page 2			
Item ID: Revision ID: Item Name: Start Date: Required Date	D2235-1  Basket Rib  2/04/13  : 2/04/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	Accept	*N900 Cust Item I Customer:		I	Setu	p Start Stop	IVI	S1* S2*
Reference: Approvals:	Process Plan:		Date:	Tooling:	Date:Date:			Run	Start	*NI	R1*
Approvais.	QC:	an.	Date: SPC (Y/N):						Stop	*NI	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Ac Code Qt	-	•	Reject Number	Insp. Stamp
*130 *130* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00				<u> [2</u>	7/4	85	**

MB-04-4

				DQA:	Date:	<u> </u>	
NCR: Yes / No	WORK ORDER NON-COI	NFORMANCE / UPI		QA Closed:	Date:		
Work Order:	DISPOSITION		AGAINST DEP	ARTMENT/PRO	OCESS		
	Rework Scrap	Skid-tube Machining	Crosstube Small Fab		Vater Jet	Engineering Quality	]
Part No.	Use-as-is	Thermoforming	Finishing	Rec/Store/Page 1	ackaging	Other	1
NCR No.	Work Order Update	Large Fab	Composite		Supplier		J

## Description of work order update Initial Action Sign & Root or Non-conformance Chief Eng Description Date Verification QC Inspector Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure BOM/Route Hardware Over/Under tolerance Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Part Lost/Missing Wrong Stock Pulled Instructions Incomplete/Unclear Crushed/Crimped, Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Out of Sequence Finish Wave/Twist in Tube Folio **Outside Dimensions**

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

96126

Parent Item:

D2235-1

Parent Item Name:

Basket Rib

**Start Date: 2/04/13** 

Required Date: 2/04/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A

New Issue 08-12-01 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-1		Manufactured	No			100	Each	16.0000	1	2	11	<b>3</b> ./	./

Location	Loc Oty Loc Code	
WA	15 B 94820	(5x)
91594	14	
94945	1	
WA006	1	
86807	ı	

NCR: Y	es / No				WORK ORDER NON-	CON	<b>IFOR</b>	MANCE / UP	DATE							
										QA Closed	: Date	:				
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering				
Part N	lo.				Scrap	1		Machining	Small Fab	<b>-</b>	od. Eng. Coor.	Quality				
			<del></del> .	Use-as-is	1	Thermoforming Finis			Rec/Sto	ore/Packaging	Other					
NCR N	lo	Work Order Update Large Fab Composite				Supplier										
							Initial Action			Cian 0	T	1				
Root		<u> </u>	ا م		ption of work order update	ļ				Sign &	Verification	QC Inspector				
Cause	Date	Step	Qty		or Non-conformance	Cn	ief Eng	Desc	ription	Date	Vernication	QC IIIspector				
Doc/Data										†						
Equip/Tooling	_										` .					
Operator	_							i								
Material																
Setup	-								0							
Other Process																
Supplier	-															
Training	-															
Unapproved																
onapproved 1					F	AUL	T CATE	GORY	1		· · · · · · · · · · · · · · · · · · ·	- L				
Landir	ng Gear				General			-								
	Bending				Bend		Grain			Ovalized		Pressure/Forced				
}	Centre N	ot Conce	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure				
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorr	ect	Weld				
	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/N	/lissing	Wrong Stock Pulled				
	Cuffs			•	Contamination		Mainte	enance	1	Part Move	d					
	Heat Trea	at			Countersink		Mislabe	eled		Positioned	Wrong	<del></del> -				
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss	s/Surge	Other				
	Ripples ir	Bend			Drill Holes		Offset		•							
	<b>├</b> ─┤ `` <b>├</b> ──┤				Drawing		Out of (	Calibration								

Out of Sequence
Outside Dimensions

DQA:

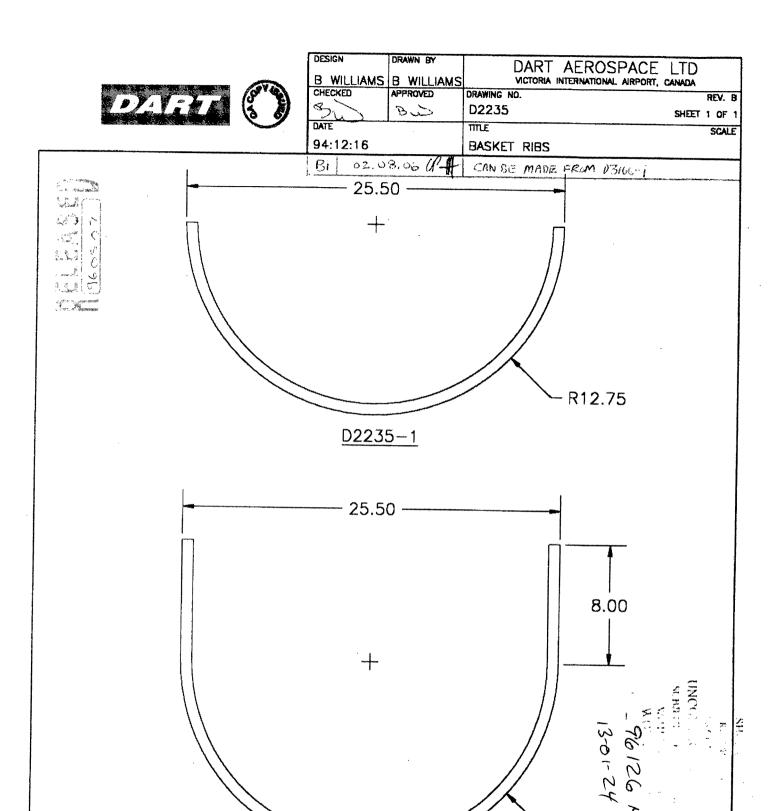
\_Date: \_

Turning Sequence

Wave/Twist in Tube

Finish

Folio



CAN BE MADE FROM 03166-1 (B) MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

D2235-3

R12.75